

Date: Thursday, 17/08/2006 3:29:35 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY 25"
Job Number : 28229	
Estimate Number : 11190	
P.O. Number : N/A	Part Number : D3298001
This Issue : 17/08/2006 S.O. No. : N/A	Drawing Number : D3298 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A2
Previous Run : N/A	Material : N/A
Written By : <u>W</u>	Due Date : 05/09/2006 Qty: 8 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est A04.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 17.4997 f(s)
 Cut tube to length as per Dwg D3298
 Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)
 Identify as D3298-001
 Batch: 1717931(x2) 1717666(x6)

FF 06.08.21 8

2.0	MS208196D	Sleeve
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Comment: Qty.: ~~1.0000~~ Each(s)/Unit Total : 8.0000 Each(s)
 Sleeve 2.00

Pick:

Qty	Part Number	Description	Batch
2	MS20819-6D	Sleeve	1717654

FF 06.08.21 8

3.0	AN8186D	Nut
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Comment: Qty.: ~~1.0000~~ Each(s)/Unit Total : 8.0000 Each(s)
 Coupling Nut 2.0

Pick:

Qty	Part Number	Description	Batch
2	AN818-6D	Nut	1717651

FF 06.08.21 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/08/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 25"

Job Number: 28229

Part Number: D3298001

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

FF 06.08.20 8

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/08/28 8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 54379

6/8/29 8
06/08/29 8

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/30 8

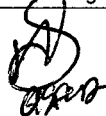
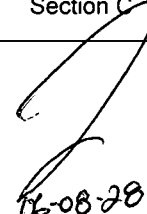
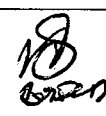
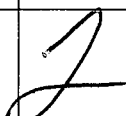
Job Completion



C206108129

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.08.20 06.08.20	4 4	one Tube too short flared one side before sleeve was on tube		scrap: destroy. replace replace: use AS template.	06.08.20 FF 06.08.20 FF	 06-08-20		 06-08-20

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3298	REV. A SHEET 1 OF 7
DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS
A	04.07.06	NEW ISSUE	
A1	04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

RELEASED
04.07.09 *[Signature]*

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

REFERENCE ONLY

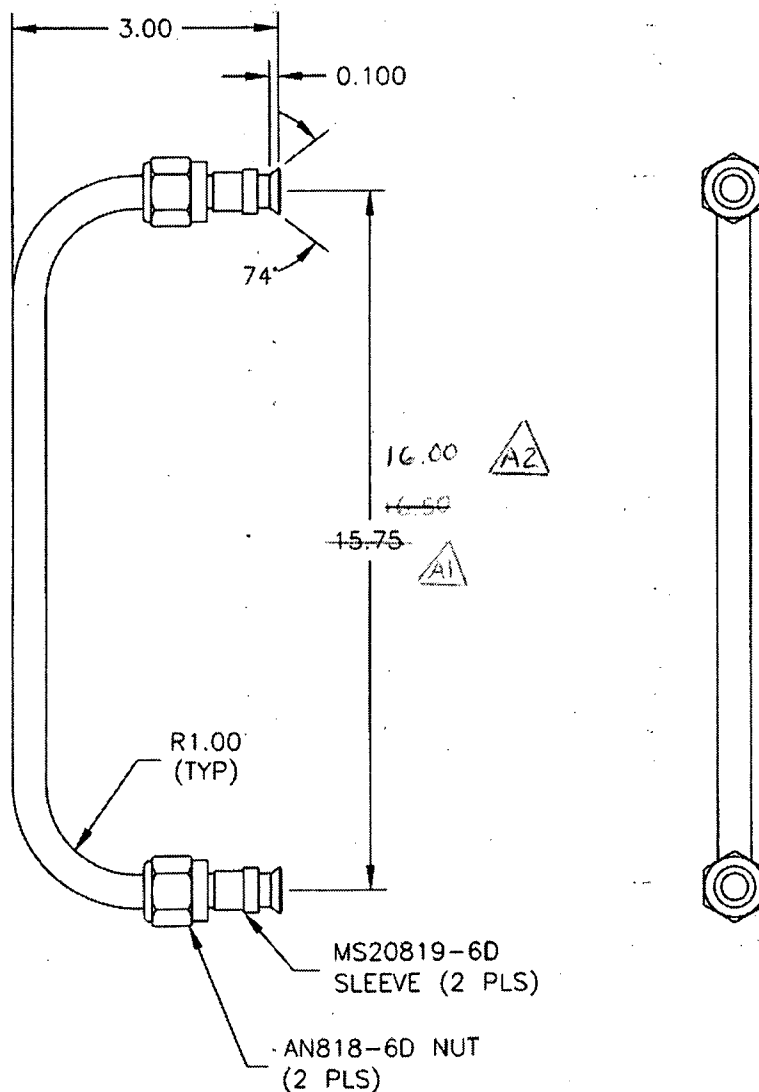
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DATE 04.07.06	TITLE TUBE ASSEMBLIES		SCALE NTS

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D3298-001

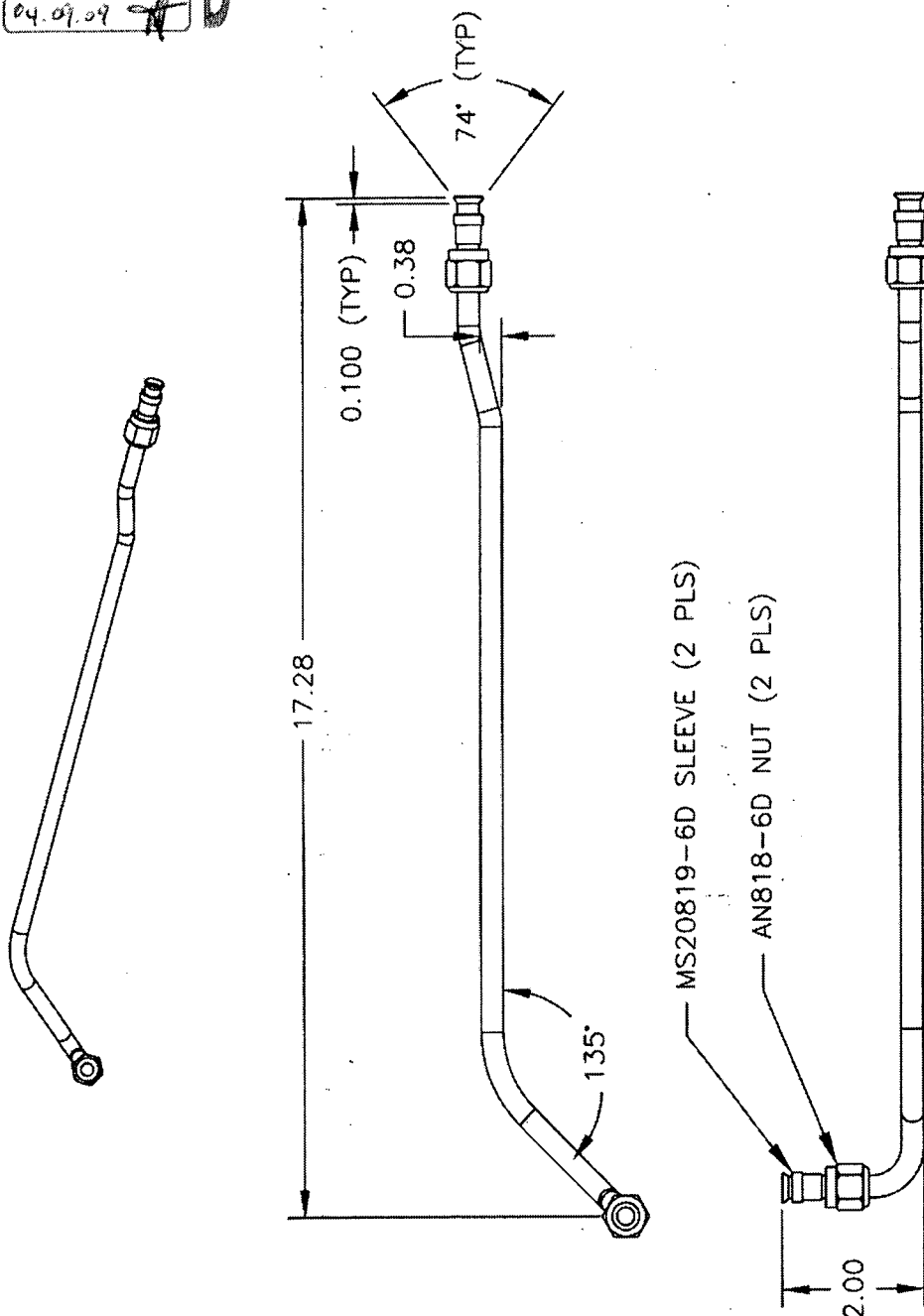
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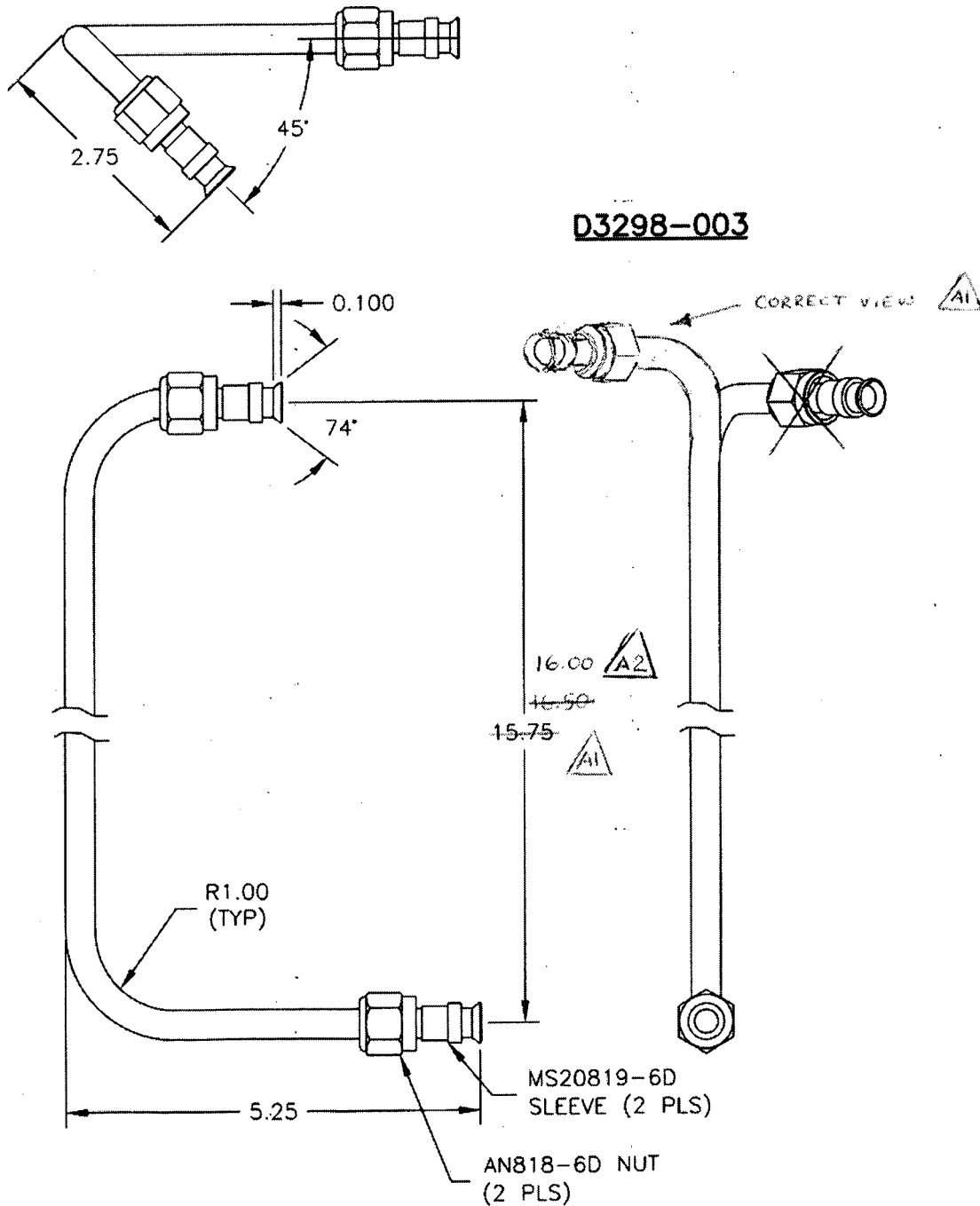
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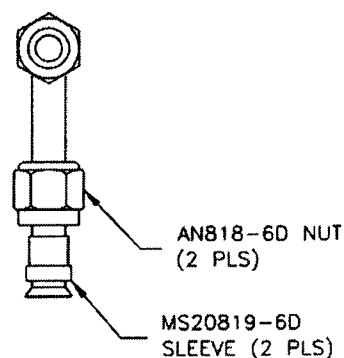
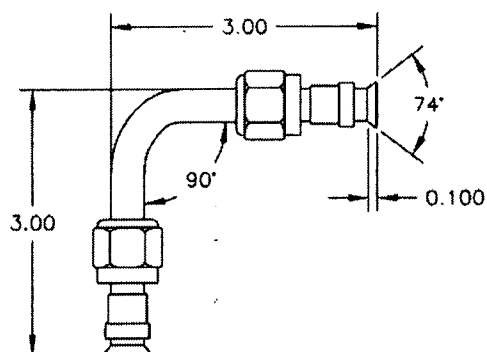
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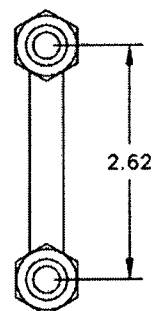
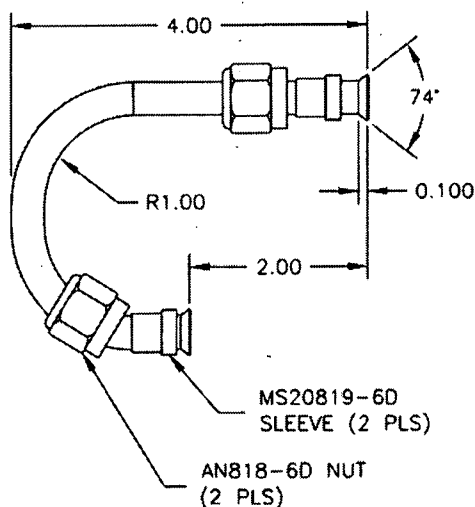


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D3298-007



D3298-013

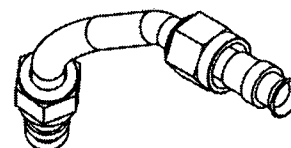
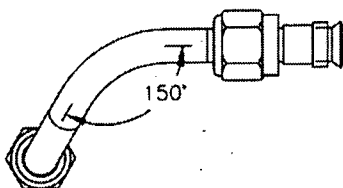
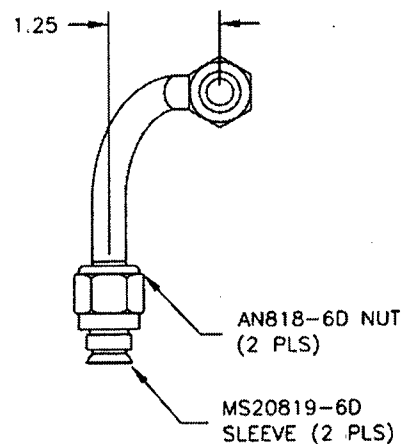
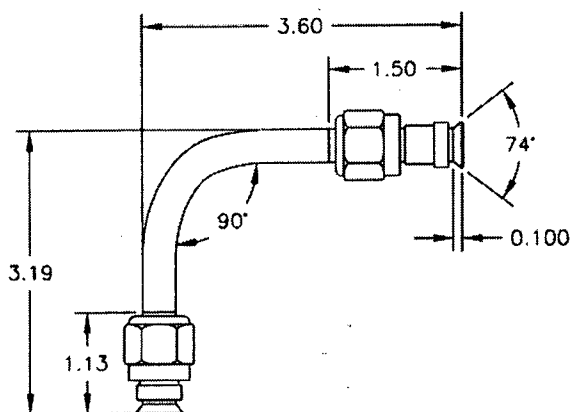
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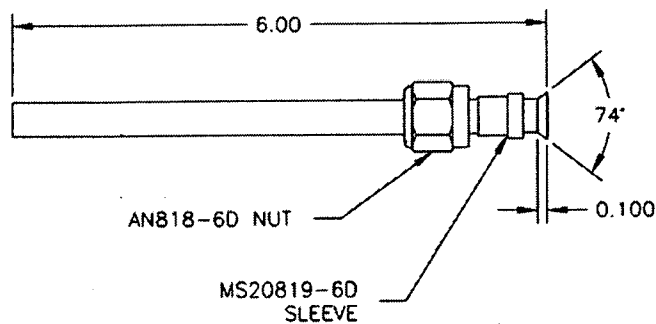


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D3298-011



D3298-009

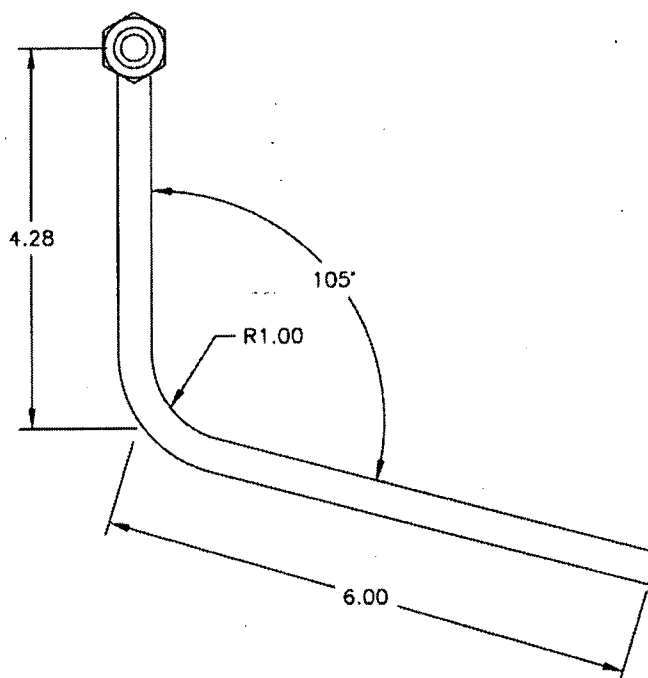
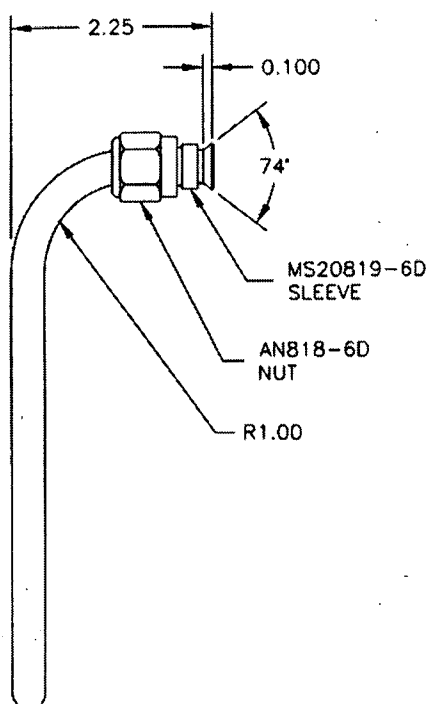
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